

5/42

DART AEROSPACE LTD		Work Order:	24335
Description: Guide		Part Number:	D3112-1
Drawing: D3112 Rev. AT B		Qty:	56

RF 02.11.14

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JP	05.09.26	5
2	METAL /CNC-CELL	Cut blanks: 0.625" x 1.500 bar x 2.625" long. Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) Bar ref DART spec M6061T6B Batch M17037	JP	05/10/21	5
3	HAAS	Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per dwg.	J.L	05.10.26	6
4	QC	Inspect Level 2	J.L	05.10.26	6
5	QC	Inspect Level 8	EN	05.10.26	6
6	METAL/CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	J.L	05.10.26	6
7	QC	Inspect Level 5	JP	05.10.26	6
8	FINISHING	Chemical conversion coat as per QSI 005 4.1	SAD	05/11/19	6
9A	FINISHING	Powder coat grey sandtex (4.3.5.6) per QSI 005 4.3.	JP	05.11.24	6
9B	QC3	Inspect work to step 9A			
10	STORES	Identify and stock Loc 84 with P/N & B/N using fine point permanent ink marker	JP	05/11/24	6
11	EXPEDITING	Close W/O Inspect level 21 Cost/part 1545	JP	05/11/24	6

Rev	Date	Change	Revised By	Approved
A	02.05.22	New Issue	NG	02.05.22

RELEASED

04/05/22

RF
02.12.10
RF
04.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 05/11/28

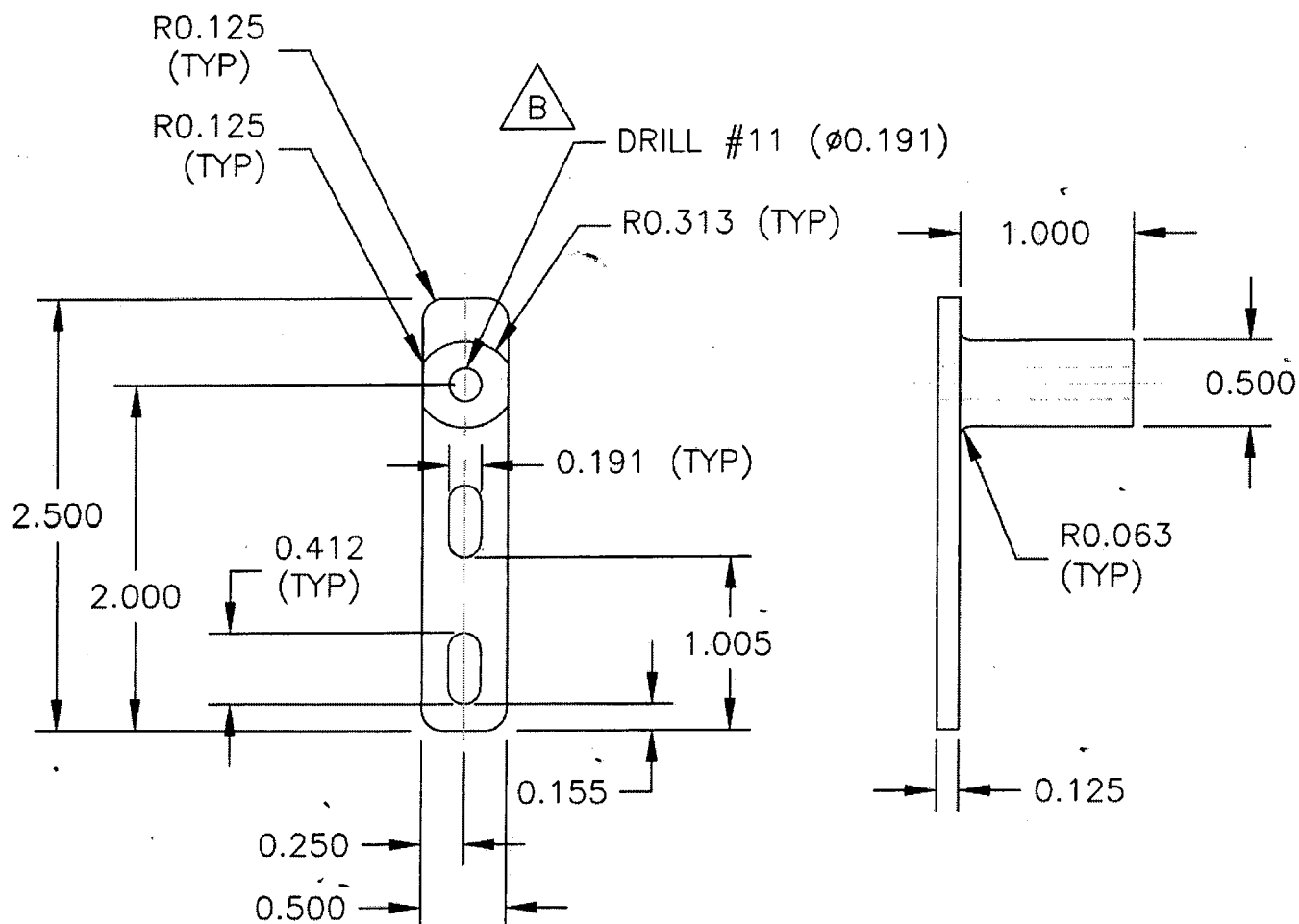
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3112 REV. B SHEET 1 OF 1	
DATE 04.10.18			TITLE GUIDE SCALE 1:1		
A	02.04.12		NEW ISSUE		
B	04.10.18		ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$		

RELEASED
04.11.23 #



D3112-1 GUIDE

1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
BAR (REF. DART SPEC M6061T6B)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- NO. 24335

SHOP COPY
RETURN TO
ENGINEERING

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SUSCEPT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24335

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024335
Project Name : D3112-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3112-1
Description : Guide
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:17 am

Work Order No : 0024335
Project Name : D3112-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3112-1
Description : Guide
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	5.00	100.00		
Production Cost :	0.00	84.85	100.00	0.00	84.85
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	5.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	84.85	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	84.85			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-84.85)

MIS 1/B
w
11-13

Date: Monday, 14/11/2005 8:37:45 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 24335		
Estimate Number	: 10367		
P.O. Number	:	Part Number	: D31121
This Issue	: 14/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3112 REV B
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 30/11/2005
Checked & Approved By	:	Qty:	5
Comment	: Est. A 02.05.22 New Issue NG	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 0.625" x 1.500 bar x 2.625" long.		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per dwg. Deburr break all unmarked sharp edges .005 to 0.010		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

Date: Monday, 14/11/2005 8:37:45 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 24335

Part Number: D31121

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

